

Date: Monday, 14/04/2008 1:06:55 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SKIDTUBE ASSEMBLY
Job Number : 38587	
Estimate Number : 10022	
P.O. Number :	Part Number : D205634011
This Issue : 14/04/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : N/A
Previous Run : 38586	Material :
Written By :	Due Date : 30/04/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JD 08.4.14</u>	
Comment : Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011 CHG005

5 08/05/01 08.4.21 JLD

2.0	38587A	SKID TUBE ASSEMBLY
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**Comment:** Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B 38587

A

SLP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

4.0	K10003	Saddle, D205-634-011
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1X

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	37901

8/5/11

SLP

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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**Comment:** INSPECT 100% KITS FOR COMPLETENESS

5 08/05/01 08.4.21 JLD

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 14/04/2008 1:06:55 PM
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Process Sheet

✓ Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 38587

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



(N)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: 2

JS 08/05/01

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/05 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				AN960JD616	WASHER
29	16	16				AN4-6A	BOLT
30	32	32				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D2968-041	TOW RING
41	1	1				AN970-4	WASHER
43	1	1				MS21042L4	NUT (OR MS21042-4)
50					1	D2736-1	GHW LUG
51					1	D2736-3	GHW LUG
52					4	AN4-46A	BOLT
53					8	D2570	BUSHING
54					4	MS21042L4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

SHOP COPY
RETURN TOENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38587

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Revision: D

Date: 07.04.10

Date: Monday, 14/04/2008 1:07:12 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY
 Job Number : 38587A
 Estimate Number : 10023
 P.O. Number :
 This Issue : 14/04/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : LANDING GEAR
 Previous Run : 38586A
 Part Number : D205634041
 Drawing Number : D2580 REV D
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 30/04/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JLD 08.4.14
 Comment : Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 Est Rev. O 06.02.28 Added paperwork EC
 Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG002

N/A

2.0 D25001190 Ext'n -1' Beam Tube 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

B-34729 AWM 8-4-17

3.0 D2596 Web, 205 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2596

205 Web

B-38642 AWM 8-4-18

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends

3-Acid etch and Alodine tube per QSI 005 4.1

AWM 8-4-17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Date: Monday, 14/04/2008 1:07:12 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38587A

Part Number: D205634041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

REF 08/04/18

6.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580without cutting fluid

3-Countersink holes as per Dwg D2580without cutting fluid

4-Deburr and blow out all chips from inside of tube

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291	12107397	
Sikaflex expire date:		8-10-21	
Start Time:		9:20	Date: 8-4-18
Fin Time:		1:45am	Date: 8-4-21

- AWM
8-4-18

7.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

ELI Job 8-4-21

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required.

ET 08-04-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38587A

Part Number: D205634041

Job Number:



Seq. #: Machine Or Operation: Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 0064(250)

10.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	<i>33321</i>

BE 08/04/28

11.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	<i>37752</i>

BE 08/04/28

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

m107263

BE 08/04/28

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

m107263

BE 08/04/28

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

SL 8-4-29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38587A

Part Number: D205634041

Job Number:



Seq. #: Machine Or Operation: Description :

13.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/04/29 (40)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/29 (40)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Pressure wash as per QSI 005

M-A 08/04/29

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107550

08-04-30

1338587A
D205634041
30/04/2008
S.157
#1 10.22
#2 324.2
#3
#4 36mm
F

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-04-30

18.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cap
Batch: B37570

BR.

19.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M100188

BR.

20.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: M104885

BR

BR 08-04-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Monday, 14/04/2008 1:07:13 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38587A

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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21.0	ALS71032130	Insert
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*



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

Batch: NA 105819

BL

22.0	AN3C4A	BOLT
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Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

BOLT

Batch: M 107715

BL

23.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

washer

Batch: M 107823

BL

24.0	D356613	GASKET
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B32744

BL

25.0	D35665	GASKET
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B38298

BL

26.0	D35661	GASKET
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B38410

BL

27.0	D356413	WEARSHOE
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B38047

BL

BL 08-04-30 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38587A

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0	D356411	WEARSHOE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B38548

BR.

29.0	D35649	WEARSHOE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B38408

BR.

30.0	D35645	WEARSHOE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B38409

BR.

31.0	D25943	O-Ring
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

O-Ring

Batch: B29908

BR.

32.0	D25941	Plug
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Plug

Batch: B37409

BR.

33.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

Sikaflex expire date:

08-10

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

RB
BR 08-04-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38587A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date:

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M107380

M107804

08-10

08-05-30

08/04/30

34.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

73 PPP 38 387

8/5/1

14

50

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/05

Job Completion



mf 08-05-01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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NO. 149

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 383873
Part number: D205 634 041
Description: skid tube 205
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass ☒ fail ☐
pass ☒ fail ☐

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐

Qualifier Pat Duval Date of Test Coupon 08-04-18

Welder Barclay Elliot Date of Test Coupon 08-04-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Diagram illustrating the cross-section of a circular beam with four vertical reinforcement bars. The diameter of the beam is 16 inches. The spacing between the bars is 3.500 inches. The distance from the centerline to the center of each bar is 1.750 inches. The bars are labeled 1, 2, 3, and 4 from left to right.

RELEASED
07-06-28

Diagram illustrating the grinding locations for the D2576-3 STEP. The diagram shows a cross-section of the component with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Technical drawing of a bolt assembly. The drawing shows a cross-section of a bolt and nut assembly. The bolt is labeled "AN3-5A BOLT (1)". The nut is labeled "AN960JD10L WASHER (1) (2 PLACES)". The cap is labeled "D2855 CAP". The assembly is labeled "DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)". The drawing also shows a "SEAL WITH SIKAFLEX-241/-291" and a dimension of "0.40". The bolt diameter is indicated as "Ø0.208".

D2579 SPACER

WEB (REF)

1.50 (REF)

AFTER PERFORM
1. CHA
2. INSU
3. WEL

1. CHAMFER HOLE 0.050 X 45°

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i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

Diagram showing the elevation view of the bridge deck. The deck width is 37.50. The distance to the aft end of the D2596 web is 37.50. The deck is divided into two sections, 3 and 7. The deck is supported by a web. The web is 1.750 wide. The deck is 8.750 wide. The deck is 17.375 wide. The deck is 26.000 wide. The deck is 34.188 wide. The deck is 91.500 wide. The deck is 190.0 wide. The deck is (D2500-1). The deck is 57.313 (REF) wide. The deck is 7 EQUAL SPACES wide. The deck is 8.188 PITCH wide. The deck is 0.508 (TYP.) wide. The deck is (40 PLACES) wide. The deck is REFER TO DETAIL A.

Technical drawing of a road cross-section showing two drainage holes. The left hole is 1.4 units above the road surface and 13.4 units from the tangent point. The right hole is 20.0 units from the tangent point, has a diameter of 0.640, and is 11.5 units above the road surface. Both holes are 1.0 unit from the tangent point. The distance between the holes is 32.0 ± 1.0 units.

D-2000 OFF ROAD VEHICLE ASSEMBLY DETAIL B

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5 1.5 1.5 1.5

8

P P P P P P P

REFER TO DETAIL C

D3566-1 D3566-5 D3566-1 D3566-13

D3564-11 D3564-5 D3564-9 D3564-13

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

DESIGN	JJ	DRAWN BY	
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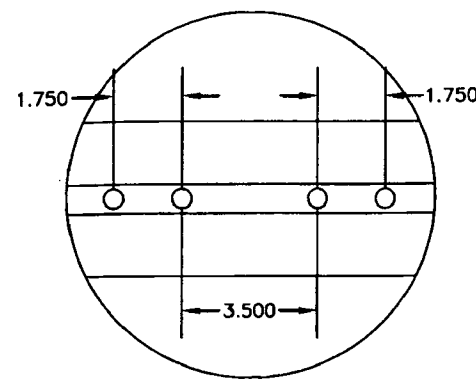
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205 SKIDTUBE ASSEMBLY

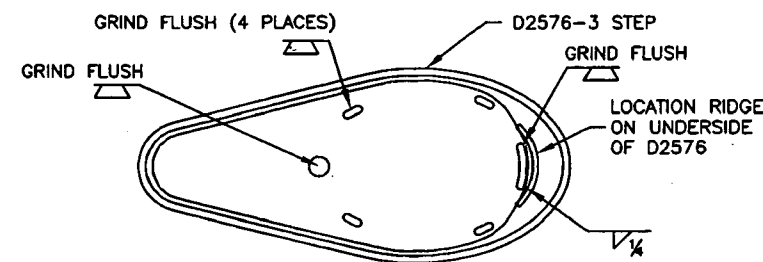
1:24

DETAIL E
SCALE 5:24

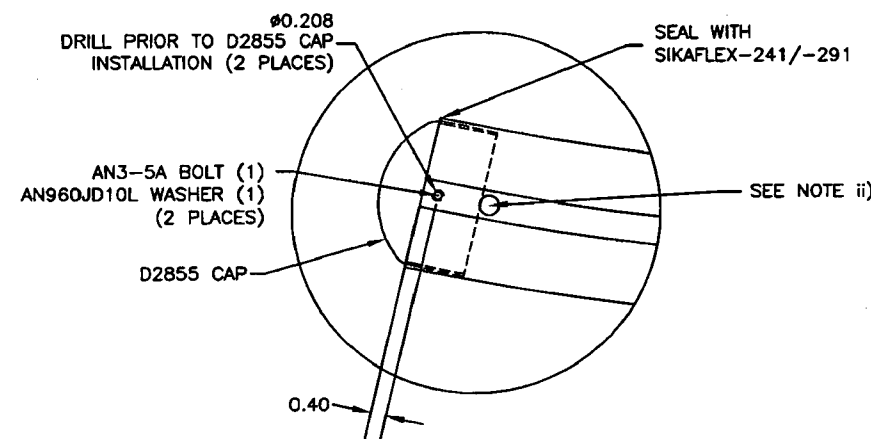


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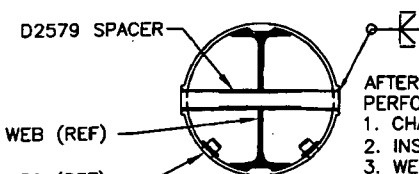
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24



SECTION H-H
SCALE 5:24

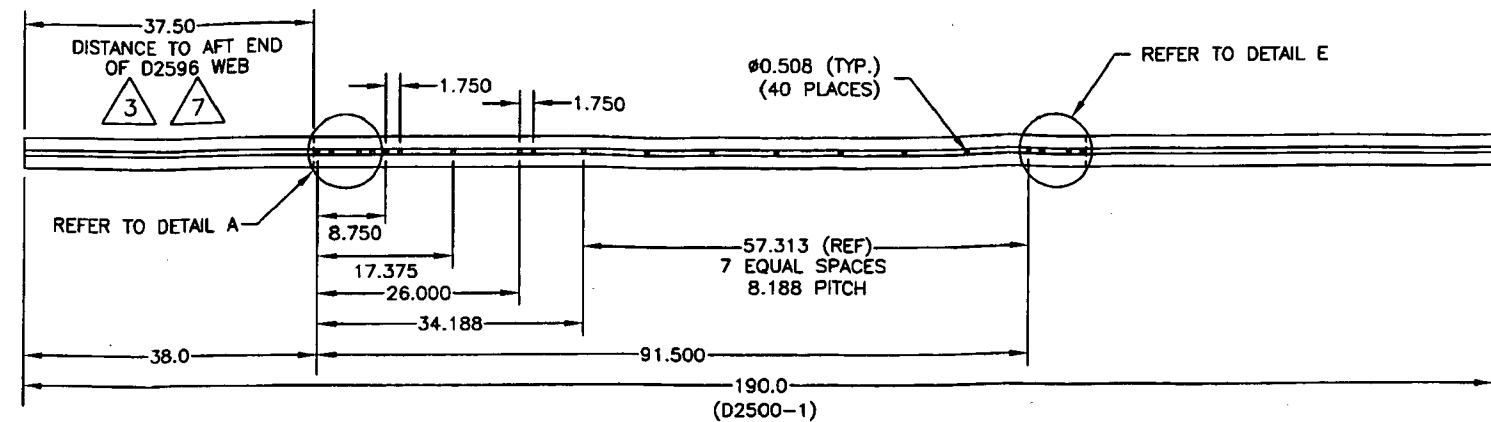


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

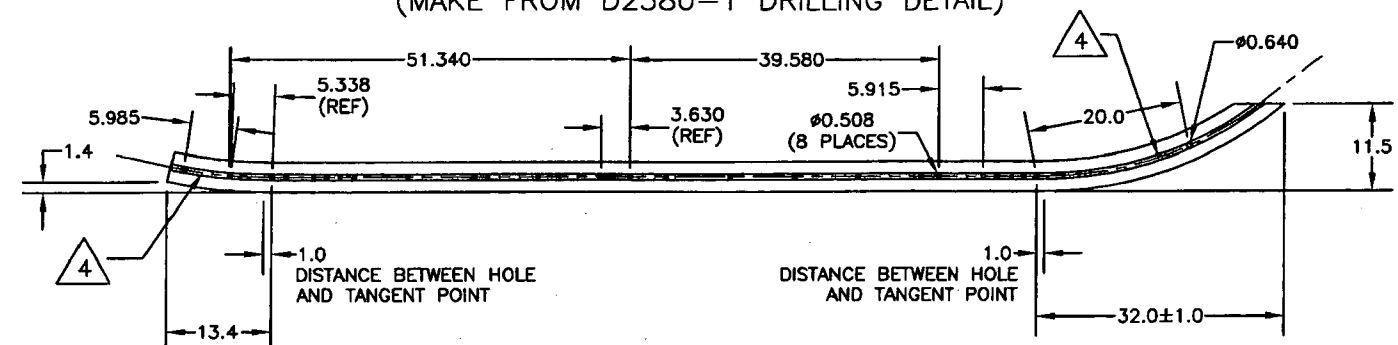
D2580-045 NOTES

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

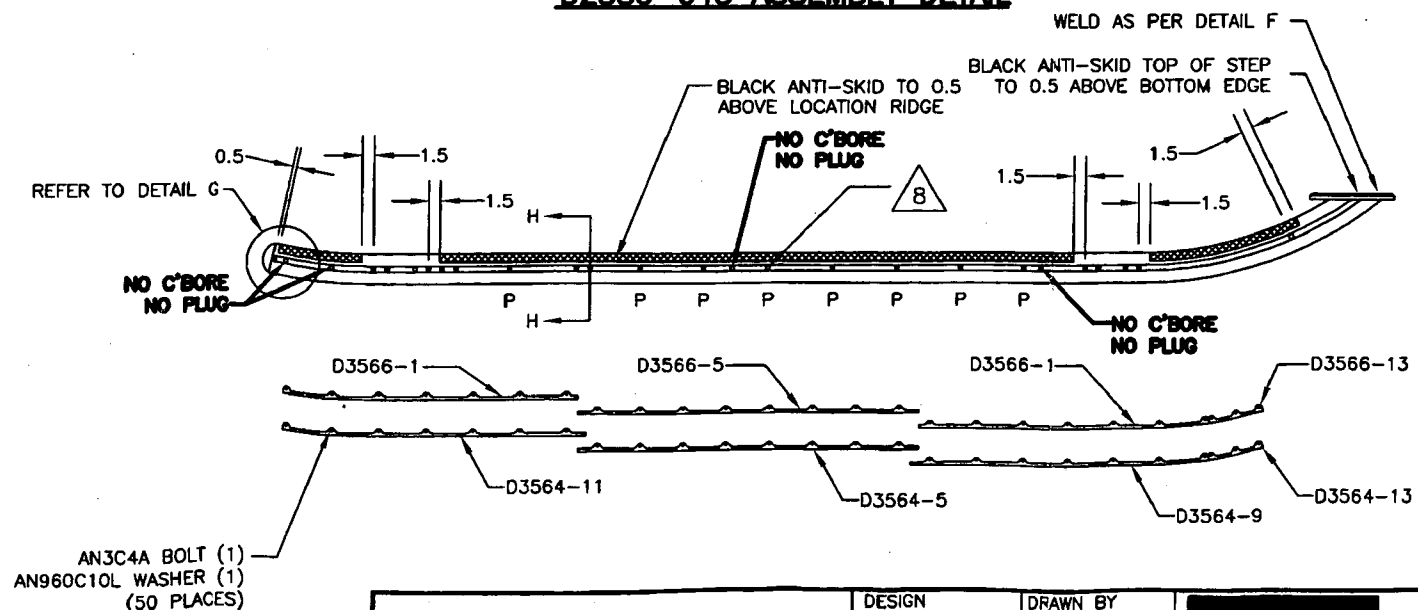
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

